

# NPN

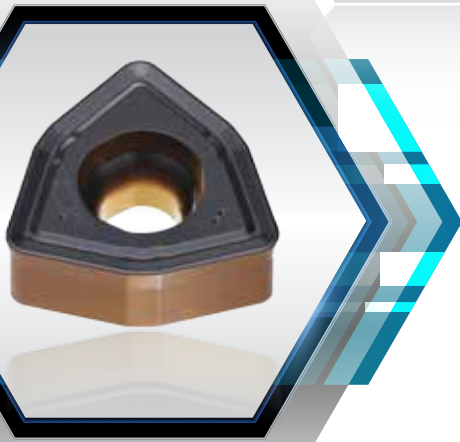
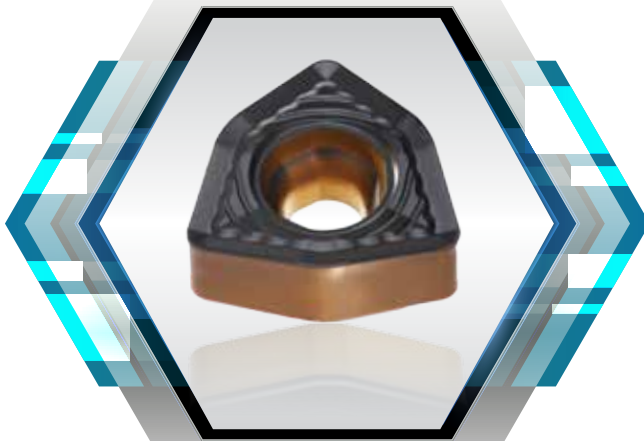
New Product News



## TURN SFEED

HIGH FEED TURNING

**High-Feed Turning Positive Inserts  
and Holders for Left or  
Right Bi-directional Turning**



## KEY POINT

**TaeguTec has released a new high-feed turning positive inserts and holders  
TURN-SFEED capable of both left and right bi-directional turning.**

To improve productivity, TaeguTec has released a high feed turning insert line demonstrating good chip control with holders which can machine both left and right directional turning applications without having to change the tool holder.

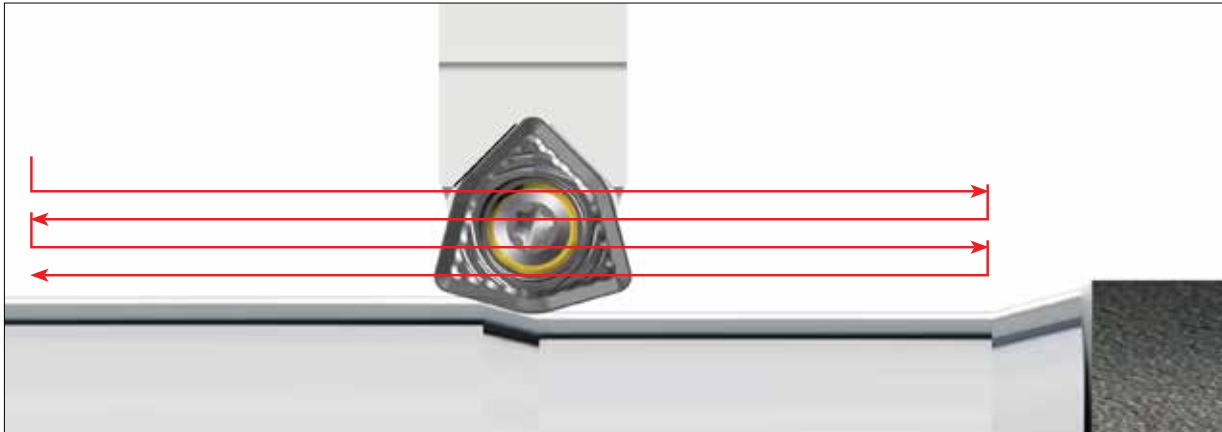
The TURN-SFEED line enables both left and right directional turning using one neutral type of holder, and the positive-type insert is designed with anti-rotating grooves on the bottom side as well as strong screw clamping for more robust clamping that generates good performance during high-feed turning.

### Features

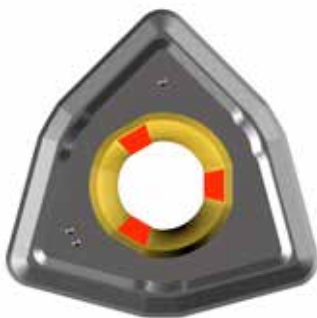
- Productive high-feed turning with a maximum 3 mm/rev feed and maximum 2 mm depth of cut
- Positive type insert with 6 cutting edges (3 index) and optimized chip breaker
  - Left or right bi-directional continuous turning with one neutral type of holder
  - Reduced cycle time and inventory of holders
  - Good chip control and low cutting force
- Anti-rotating groove design and special screw clamping for more stable machining
- Internal coolant supply from upper and lower sides for good chip control and tool life
- TT8115, TT8125, TT8135 are bi-colored CVD coated grades for improved machining performance



## Capable of left and right bi-directional continuous turning



## Screw hole and grooves for anti-rotating



Special screw hole

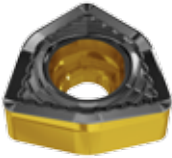
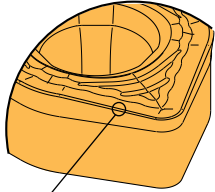
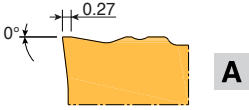

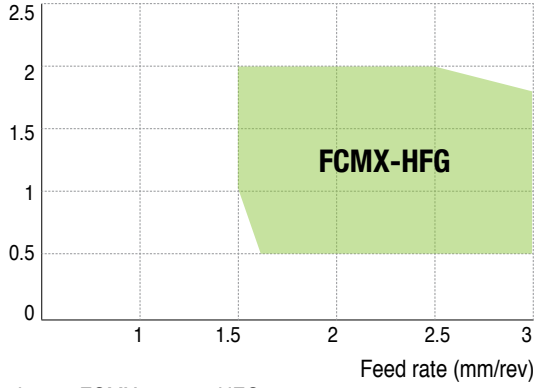
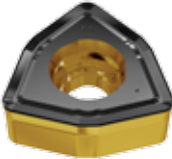
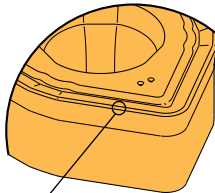
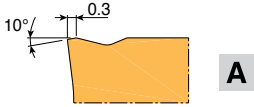
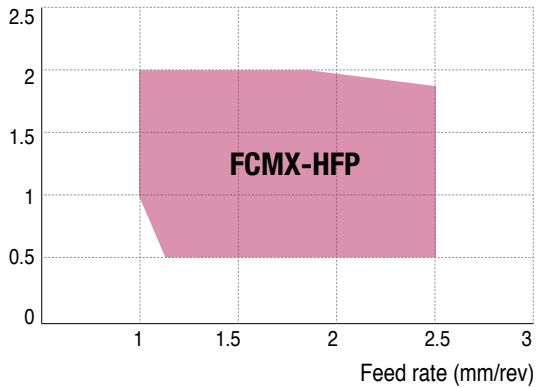


3 grooves on bottom side

## Upper and lower coolant supply



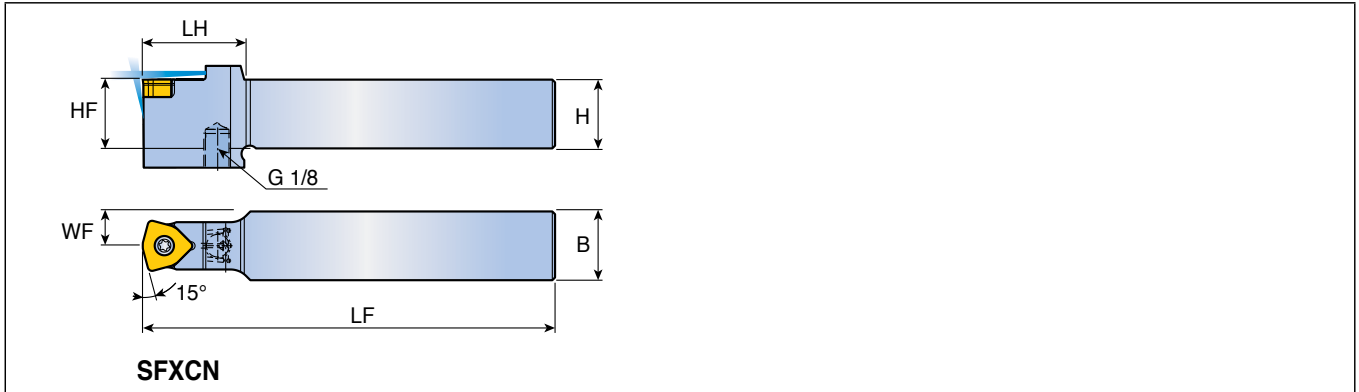
## FCMX chip breaker geometry and chip control range

Chipbreaker	Cutting edge geometry	Graph
 <p><b>HFG</b></p> <ul style="list-style-type: none"> <li>• High feed turning for general purpose in steel and stainless steel</li> <li>• Low cutting force with special inclination (6°) design</li> <li>• Heat radiator design for effective cooling</li> </ul>	 <p><b>A</b></p>  <p><b>A</b></p>  <p><b>A</b></p>	<p>Depth of cut (mm)</p>  <p><b>FCMX-HFG</b></p> <p>Feed rate (mm/rev)</p> <ul style="list-style-type: none"> <li>• Insert: FCMX 100616-HFG</li> <li>• Cutting speed (V): 150 m/min</li> <li>• Material: AISI 1045 (HB200-230)</li> </ul>
 <p><b>HFP</b></p> <ul style="list-style-type: none"> <li>• High feed turning for steel, especially in alloy steel</li> <li>• Strong cutting edge</li> </ul>	 <p><b>A</b></p>  <p><b>A</b></p>	<p>Depth of cut (mm)</p>  <p><b>FCMX-HFP</b></p> <p>Feed rate (mm/rev)</p> <ul style="list-style-type: none"> <li>• Insert: FCMX 100616-HFP</li> <li>• Cutting speed (V): 150 m/min</li> <li>• Material: AISI 1045 (HB200-230)</li> </ul>

## SFXCN





### Screw type holders with internal coolant supply



Approach angle	Designation	Dimension (mm)						Insert
		H	HF	B	LF	LH	WF	
<b>15°</b>	<b>SFXCN 2525 M1006</b>	25	25	25	150	37	12.5	FCMX 1006...
	<b>3232 P1006</b>	32	32	32	170	37	16	

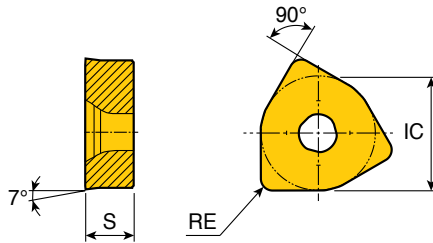
### Spare parts

Designation	Screw	Wrench			
<b>...1006</b>	 SO 45130I	 T 20			

## FCMX



### Positive high feed inserts



Size	Dimension (mm)		
	IC	S	RE
<b>10</b>	15.45	6.5	1.6

Insert	Designation	ap (mm)	Feed (mm/rev)	Cermets		CVD coated										PVD coated						
				PV3010	CT3000	TT7005	TT7015	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080		
	<b>FCMX 100616-HFG</b>	0.5-2.0	1.5-3.0						●	●		●										
	<b>FCMX 100616-HFP</b>	0.5-2.0	1.0-2.5						●	●	●											

●: Standard items

## KIT COLLECTIONS

These kit products are available in the format listed below.



Cat. No.	Designation	Bill of materials	Qty.
6334754	<b>KISFT-SFXCN 32-FC1006 HF</b>	SFXCN 3232 P1006	1
		FCMX 100616-HFG TT8125	3
		FCMX 100616-HFP TT8125	3



Cat. No.	Designation	Bill of materials	Qty.
6334767	<b>KISFS-SFXCN 32-FC1006 HF</b>	SFXCN 3232 P1006	1
		FCMX 100616-HFG TT8125	20



Cat. No.	Designation	Bill of materials	Qty.
6338409	<b>KISFF-A-FC1006 HFG TT8125</b>	FCMX 100616-HFG TT8125	100
6338410	<b>KISFF-B-FC1006 HFG TT8125</b>		300
6338411	<b>KISFF-A-FC1006 HFP TT8125</b>	FCMX 100616-HFP TT8125	100
6338412	<b>KISFF-B-FC1006 HFP TT8125</b>		300